

Work Order ID 129609

Thursday, February 19, 2015 1:52:11 PM

129609

Stack
Thursday

Page 1

Item ID: D117-840-011

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Bearpaw with Wearplates

Start Date: 2/20/15 Start Qty: 4.00

4

Cust Item ID:

Required Date: 2/27/15 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

15-2-19

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
IIN-D117-840	A

MLJ 1503-11

100 Document Control
DOCUMENT CONTROL

0.00

DAS
27
9-89

100

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP D117-840-011 CHG 001

4x

DAS
46
9-89

MAR 16 2015

160 Pick Kit

0.00

160

Packaging

Memo

0.00

Packaging

X4

DAS
27
9-89

MAR 11 2015

170 QC4- 100% Inspect kits for completeness

0.00

170

QC

Memo

0.00

Quality Control

4x

DAS
46
9-89

MAR 16 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

Work Order ID 129609

129609

Page 2

Thursday, February 19, 2015 1:52:11 PM

Item ID: D117-840-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bearpaw with Wearplates

Start Date: 2/20/15 Start Qty: 4.00 *4*

Cust Item ID:

Required Date: 2/27/15 Req'd Qty: 4.00 *4*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Packaging	0.00				(4x)	DAS 46		
180							9-89	MAR 16 2015	
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D117-840-011								
	Location: <u>RG05</u>								
	PPP Rev: _____								
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

MCJ 1503-17

W1503-17

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Equip/Tooling									
Handling/Pre									
Material									
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Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Thursday, February 19, 2015 1:52:15 PM

Page 1

Work Order ID: 129609

129609

Parent Item: D117-840-011

D117-840-011

Parent Item Name: Bearpaw with Wearplates

Start Date: 2/20/15

Required Date: 2/27/15

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 13-04-01 JLM VERIED BY:DD IPP
REV:B 13.05.28 PER IIN D117-840 REV.A DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2274

D2274

Radius Block

DAS
46
9-89

Manufactured No

Each 40.0000

8

32

**

DAS

27

9-89

MAR 12 2015

Location

Loc Qty

Loc Code

FG

12

86855

12

ST005

2

128474

2

ST012a

26

121589

24

124363

2

B12984

32

D3456-1

D3456-1

Washer

DAS
46
9-89

Manufactured No

Each 125.0000

12

48

**

DAS

27

9-89

MAR 11 2015

Location

Loc Qty

Loc Code

FG

7

25701

7

ST040

68

121045

68

ST051A

50

128456

50

48

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Page 2

Thursday, February 19, 2015 1:52:15 PM

Work Order ID: 129609

129609

Parent Item: D117-840-011

D117-840-011

Parent Item Name: Bearpaw with Wearplates

Start Date: 2/20/15

Required Date: 2/27/15

Start Qty: 4.00

Required Qty: 4.00

D4012-1 Manufactured No

Each 6.0000

D4012-1
Cushion

DAS
46
9-89

**

4 16

DAS
27
9-89

12961714

MAR 11 2015

Location

Loc Qty

Loc Code

FG

4

97172

4

ST545

2

119517

2

Each

0.0000

**

2 8

DAS
27
9-89

8 129611

MAR 11 2015

D4796-1

D4796-1

Bearpaw

D4798-041

Manufactured No

Each

8.0000

**

2 8

DAS
27
9-89

MAR 11 2015

D4798-041
Wearplate Assembly

DAS
46
9-89

Location

Loc Qty

Loc Code

ST608

8

114325

8

Each

3.0000

**

4 16

DAS
27
9-89

MAR 11 2015

D4799-1

D4799-1

Clamp

DAS
46
9-89

Manufactured No

Loc Qty

Loc Code

ST545

3

114203

3

B129612

3

B

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

Picklist Print

Thursday, February 19, 2015 1:52:15 PM

Work Order ID: 129609

129609

Parent Item: D117-840-011

D117-840-011

Parent Item Name: Bearpaw with Wearplates

Start Date: 2/20/15

Required Date: 2/27/15

Start Qty: 4.00

Required Qty: 4.00

AN4C11A Purchased No Each 70.0000

AN4C11A
bolt

DAS
46
9-89

Location

Loc Qty

Loc Code

ST312A

45

m128324

45

ST344

25

m131320

25

Each

56.0000

8

32

**

DAS

27

9-89

MAR 11 2015

AN4C17A Purchased No Each 56.0000

AN4C17A
BOLT

DAS
46
9-89

Location

Loc Qty

Loc Code

ST343

56

114523

56

Each

861.0000

20

80

**

DAS

27

9-89

MAR 11 2015

MS21043-4 Purchased No Each 861.0000

MS21043-4
Nut

DAS
46
9-89

Location

Loc Qty

Loc Code

FG

40

104603

40

GA

490

m128798

490

ST304

331

m128798

297

m128818

34

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Transport									
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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Thursday, February 19, 2015 1:52:16 PM

Work Order ID: 129609

129609

Parent Item: D117-840-011

D117-840-011

Parent Item Name: Bearpaw with Wearplates

Start Date: 2/20/15

Required Date: 2/27/15

Start Qty: 4.00

Required Qty: 4.00

NAS1149D0463J

Purchased

No

Each

2,662.000

8

32

NAS1149D0463.J

WASHER

DAS
46
9-89

**

DAS

27

MAR 11 2015

DAS

27

Location

Loc Qty

Loc Code

CA

397

M129682

397

GA

408

M129390

408

ST260a

1151

M129390

1151

ST269

706

M130799

706

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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4.0 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D117-840-011	27.7 lb	0.0 in	0.0 lb-in	204.1 in	5653 in-lb
Bearpaw Installation	12.6 kg	0.0 mm	0.0 mm-kG	5200 mm	65,520 mm-kG

5.0 PARTS LIST

QTY -011	Part Number	Description
X	D117-840-011	BEARPAW INSTALLATION
8	D2274	RADIUS BLOCK
12	D3456-1	WASHER
4	D4012-1	CLAMP CUSHION
2	D4796-1	BEARPAW
2	D4798-041	WEARPLATE ASSY
4	D4799-1	CLAMP
12	AN4C11A	BOLT
8	AN4C17A	BOLT
20	MS21043-4	NUT
8	NAS1149D0463J	WASHER